

ABSTRACT

A chill block made from copper bonded to tool steel is disclosed. A tool steel layer of the chill block of less than about 0.5 inches thick is present on the parting surface of the chill block or chill block face. A tool steel layer may also be present on a portion of the sides of the chill blocks and/or the bottom of the chill block. Chill blocks in accordance with the present invention allow molten metal to solidify in the passageway formed by a pair of chill blocks, and provide for efficient manufacturing of objects by die casting methods.